Work Order ID 81819 March-19-12 3:40:37 PM				*81819*							Page 1
Item ID: D407- Revision ID:	-667-205TRN			Accept	*N900	040	1100)* ፡	Setup Star	' *N	S1*
Item Name: Crosst	ube Turning Deta	il							Sto	' *N	S2*
Start Date: 19/03/	/2012 Start (Qty: 1.00	*1*		Cust Item	ID:					
Required Date: 02/04/ Reference:	/2012 Req'd	Qty: 1.00	*1*		Customer:						
Approvals: Proc	ess Plan:M	して	Date: 12 03 10	Tooling:	D	ate:		F	Run Star	1/1	R1*
QC:			Date:	SPC (Y/N):	D	ate:			Stop	` *N	R2*
Sequence ID/ Work Center ID	Operat Descrip			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nb	r									
D407-667-245	Rev F										
100				\$ '0.00							
100	MORI SE	IKI CNC LATI	HE LARGE							K	E 12/4
Mori Seiki Mori Seiki CNC Lathe Large		Memo I-Fill tube w	rith sand & install plugs D	0.00 0T8531 on both ends as pe	r Folio FA248						/
			side as per Folio FA248								
	3	FOLIO REV DWG REV:	sition lines only, **do not :	:					·		
		*Do not use	sandpaper coarser than 32	0 grit.						4	
110	QC1- Insp	ect dimensions	to dimension sheet	0.00						•	
*11 0 *		Memo		0.00						 . ————————————————————————————————	

Quality Control

MM.L 12/04/11

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Dan Ae	rospace	s Lla							•
W/O:			W	ORK ORDER CHANGE	ES				4
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A :	Date:	
	R	lesolution:	Disposit	ion:	QA: N/C CI	osed:		Date: _	
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (NCF	R)			
D.4.T.F	0.750	Description of NC	Corrective Action		n B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
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Work Order ID 81819 March-19-12 3:40:37 PM				*81819*						Page 2			
Item ID: Revision ID: Item Name:	D407-667-2 Crosstube Tu			Accept	*N900	104 0	100)*	Setup S		IS1* IS2*		
Start Date: Required Date: Reference:	19/03/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer					IX.	1.57		
Approvals:		an:	Date:	Tooling: SPC (Y/N):		Date:		I		tart *N	IR1* IR2*		
Sequence ID/ Work Center II 20)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp		
120 Mori Seiki Mori Seiki CNC Latl	ne Large	2-Blend trar *Use mill ba *Do not use FOLIO REV DWG REV:	nd side as per Folio FA2 nsition lines only, **do r astard file, brush file rep sandpaper coarser than	not sand whole tube**: eatedly with file card.						<i></i>	L 12/4		
30			uff(Donot engrave on ou	orating stylus as per Dwg Detside of tube) 0.00	407-667-245								
'13 0*													

0.00

Memo

Quality Control

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W/O:		WORK ORDER	WORK ORDER CHANGES					
DATE	ŞTEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector	
Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	A:	_ Date: _		
	Resolution:	Disposition:	QA: N/C C	losed:		Date: _		

NCR:			WORK ORDER NON-CONFORMANCE (NCR)											
		Description of NC		Corrective Action Section E	3	Verification	Annuaral	Approval						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspecto						
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Work Order ID 81819 *81819* Page 3 March-19-12 3:40:37 PM Item ID: D407-667-205TRN Accept *N900040100* Setup Start **Revision ID:** Item Name: Crosstube Turning Detail Start Date: 19/03/2012 Start Qty: 1.00 **Cust Item ID: Required Date:** 02/04/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Qty Code Qty Number Stamp 140 QC8- Inspect parts - second check 0.00 *140* 0.00 Memo Quality Control 145 0.00 *145* Crosstubes 0.00 Memo Crosstubes Grind off circumferential machining marks longitudinally. 150 Crosstubes Chemical Conversion 0.00 *150* HandFXtube 0.00 Memo

Ensure no sand is in the tube before alodine.

Hand Finishing Crosstubes

12-4-19

Dart Ae	rospace L	ia.							•
W/O:			WORK ORDER O	CHANGES					,
DATE	STEP	PRO	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									
						1			
Part No	•	PAR #:	Fault Category:	NCF	R: Yes	No DQA:	!	_ Date: _	
	Resolution:		Disposition:	QA:	N/C CI	osed:		Date:	
NCR:		1	WORK ORDER NON-CON	FORMANCE	(NCR)	, <u>-</u>		. ,
DATE	STEP	Description of NC	Corrective Action		Sign &	Verifica		Approval	Approval OC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	Description of NC Corrective Action Section B				Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector			

Work Order ID 81819 March-19-12 3:40:37 PM			*81819*					Page 4			
Item ID: Revision ID: Item Name:	D407-667-2 Crosstube Tui			Accept	*N900	004010) //* Setu	p Start Stop	*NS1* *NS2*		
Start Date: Required Date: Reference:	19/03/2012 02/04/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:	ID:			IV.7/		
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):		ate:ate:	Run —	Start Stop	*NR1* *NR2*		
Sequence ID/ Work Center II 160 *160* QC Quality Control)	Operation Description QC7-Inspect Chemical C	Conversion Coat	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Cod	-	eject I	Reject Insp. Number Stamp		
170 *170* Packaging Packaging		Packaging Memo Identify and	stock in kanban rackLoc	0.00 ation: 1/6				<u> </u>	mgn.L 12/64/2		
*180 *180* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00			12-	14/	234		
							H	1200	4-23		

W/O:		WORK ORDER C	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No		PAR #· Fault Category:	NCP: Vos	No DO	۸.	Data:	L.,,				

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:	
Resolution	on:	Disposition:	QA: N/C Closed	l:	Date:	

NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR)				
		Description of NC		Corrective Action Section E	<u> </u>	Verification	Approval	Annroyal	
DATE STEP	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector	
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Picklist Print

March-19-12 3:40:43 PM

Work Order ID: 81819

81819

Parent Item:

D407-667-205TRN

Parent Item Name: Crosstube Turning Detail

D407-667-205TRN

Start Date: 19/03/2012

Required Date: 02/04/2012

Start Qty: 1.00

Required Qty: 1.00

___ mand 12/04/12

Comments:

IPP Rev:A 08-03-06 new issue DD verified by:ec IPP Rev B 08.04.02 Removed polish EC verified by: DD IPP Rev:C 08-08-19 revE as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6011-115		Manufactured	No			120	Each	21.0000	1	1			
*D6011 11	5 *								**				

D6011-115

Crosstube Material

Location	Loc Qty	Loc Code	
LG	21		
65180	1		
67798)	20		

Page 1

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE By Da		PROCEDURE CHANGE				Approval Chief Eng / Prod Mgr	Approval QC Inspector	
				*	· .					

Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
1	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	Verification	Approval	Ammuoval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector	
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DART AEROSPACE LTD	Work Order:	81819
	*	
Description: Crosstube Assembly	Part Number:	D407-667-245
Inspection Dwg: D407-667-245 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		FIRST AF	RTICLE INSP	ECTION	CHECK	(LIS)		
		X	First Article		Prototy	pe		
	spection Sheet awing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments
	2.490	+0.005/-0.000	2.494	2.490		VERN	Cai	<u> </u>
	1.832	+0.005/-0.000	1.837	1/				
	1.838	+0.005/-0.000	1.843			ì		
	1.892	+0.005/-0.000	1.897					
	2.052	+0.005/-0.000	2.054	1/				
	2.206	+0.005/-0.000	2.207					
Ε	2.521	+0.005/-0.000	2-525					
SIDE	2.633	+0.005/-0.000	2.636	~		A		
σ,	4.10	+/-0.030	4.10	_				
	4.978	+/-0.030	4.97					
	2.040	+0.000/-0.010	2031					
Rús	. 0.125	+/-0.010	1125	/				
	R0.063	+/-0.010	1063			RG		
	R0.500	+/-0.010	700	/		01.		
	2.490	+0.005/-0.000	2 495			VDRN		
	1.832	+0.005/-0.000	7.839	1/		VERI		
	1.838	+0.005/-0.000	1.842	//		1		
	1.892	+0.005/-0.000	1.896					
	2.052	+0.005/-0.000	2.053	1/				
	2.206	+0.005/-0.000	2.206					
6	2.521	+0.005/-0.000	2.523	/		Vz		
SIDE	2.633	+0.005/-0.000	2.635					
ଅ 🏻	4.10	+/-0.030	4.10	-/		VERN	CNL	-08
	4.978	+/-0.030	4.978			1		
	2.040	+0.000/-0.010	2.031					
	0.125	+/-0.010	.125	_		V		
	R0.063	+/-0.010	.063			Rb		
	R0.500	+/-0.010	·560			, R.G		
	112.91	+/-0.020	112.91	کیار		tape	mo	7.1-02
Me	asured by: MM	nl, A	udited by:			Prototype App		N/A
	Date: 12/	04/12	Date:	2-4-1	6		Date:	N/A
Rev	Date Char	nge				Pavia	ed by	Approved

Rev	Date	Change '	Revised by	Approved
Α	04.04.21	New Issue (P/O D407-667-205)	KJ/RF	Approved
В	06.03.09	Dwg Rev updated	KJ/JLM	
С	06.03.30	Tolerance revised for 4.978 dimension	KJ/JLM	
D	07.02.19	Dwg Rev updated	KJ/JLM (A	
E	09.05.20	Dwg Rev updated	KJ KJ	

W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	8						•		
Part No	<u> </u>	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A :	_ Date: _	
	R	esolution:	Dispositio	n:	QA: N/C Cld	sed:	-	Date: _	
NCR:		,	WORK ORD	ER NON-CONFORMAL	NCE (NCR) .	•	•	
DATE	STEP	Description of NC	escription of NC Corrective Action			Section B Verification			Approval
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		ULTRA SC	NIC MEAS	<u>URMENTS</u>	
Side	LOCATION on tube	R1 ,228	R2 -, 387	R3	R4
A		,2/2	.4/2		
		- 269	1 1928	<u>. </u>	
В		1,213	,379		
		1761	Part number	.81819	
			Batch number	407-667	-205
			Measured By	manit	

I te m	QTY -245	PART NUMBER	DESCRIPTION
1	х	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
2	11	D6011-115	CROSSTUBE
3	2	D2856-400-773	ABRASION STRIP
4	2	D2873-043	NUT PLATE
5	2	D2873-045	NUT PLATE
6	1	D2894-1	SUPPORT
7	2	D3190-1	CHAFING SHIELD
8	2	D3595-063-430	RUBBER CUSHION
9	14	MS20601AD4W8	RIVET (OR NA\$9302B-4-8)
10	4	MS21920-22	CLAMP
11	2	MS21920-25	CLAMP (OR MS21920-24)
12	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947- 100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

D

- 1) MATERIAL: MANUFACTURED FROM D6011-115
 - FINISHED LENGTH = 112.91±0.020
- CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART: NUMBER "D407-667-245" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 27.7 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN-OFF PART, BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO

- BENDING IS 6% BASED ON O.D.

 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.03* TO 0.06* THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS WITH D'3595-063-430 RUBBER CUSHIONS TO SECURE D2894-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE
- NOTE: MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.

 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
- OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, PER OSI 035.
- 16) INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS ON BOTTOM SIDE OF CROSSTUBE OPPOSITE D2894-1 SUPPORT.
- 17) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COMY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK URDER NO. 8/8/9 MCT

DESIGN	DART AFROSE	\ C =	I TD
REV.	DESCRIPTION	BY	DATE
Α	NEW ISSUE	CP	02.05.13
В	ADD CHAFING SHIELD	CP	03.05.21
c	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.07.26
D	ADD VIEW FOR OEM SKID HOLES, ROTATE ORIENTATION OF CLAMPS SECTION F-F, REMOVE -851 ABRASION STRIP, ADD MAGNOBOND 6398, ADD CUSHION	PH	07.02.07
E	8.02 AND 8.53 WERE 8.40 AND 8.90 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.375 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: FAR#08-21 AND ECN#1225	мв	08.07.24
F	REFORMAT NOTES TO NEW STANDARDS (ZN B8-1); RELOCATED FLAG # 6 (ZN A8-3) PER NOR 210; REMOVED REF. & ADD TOLERANCES (ZN C6-3, C4-3 & D2-3)	RF	08.11.06

DESIGN	q)	DART AEROSPACE LTI	<u> </u>			
DRAWN	RF ₂	HAWKESBURY, ONTARIO, CANADA				
CHECKED	a	DRAWING NO. R	EV. F			
MFG. APPR.	8	D407-667-245 SHEET	1 OF 4			
APPROVED	111	TITLE	SCALE			
DE APPR.	74	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS			
DATE 08.1	1.06	COPYRIGHT @ 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PREVATE AND CONTRIDENTIAL AND ITS SUPPLIED ON THE EUROPES CONTRIDENTIAL AND ITS SUPPLIED TO ANY PHIRPOSE OR COPPED OR LOCALIZACE OF TO ANY OTHER PERSON WRITTEN PERSONS FROM DART AEROSPACE LTD.	THAT IT IS WITHOUT			

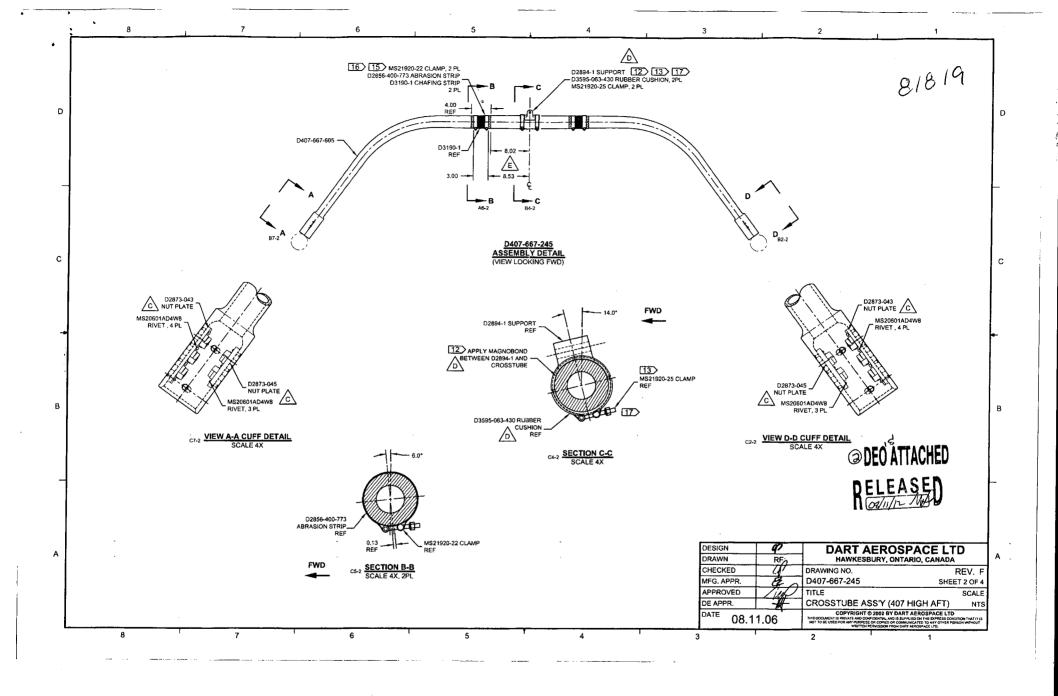
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W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
					:			
Part No	:	PAR #: Pault Category: NC	R: Yes	No DQ	\ :	Date: _		

Disposition: _____ QA: N/C Closed: ____ Date: ____

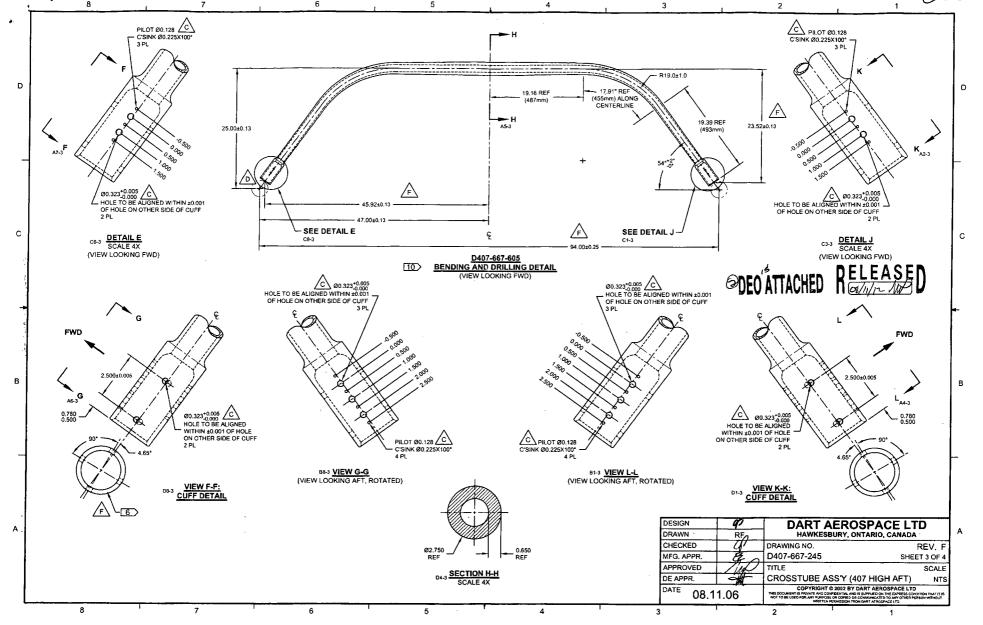
NCR: WORK ORDER NON-CONFORMANCE (NCR)									
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Resolution:



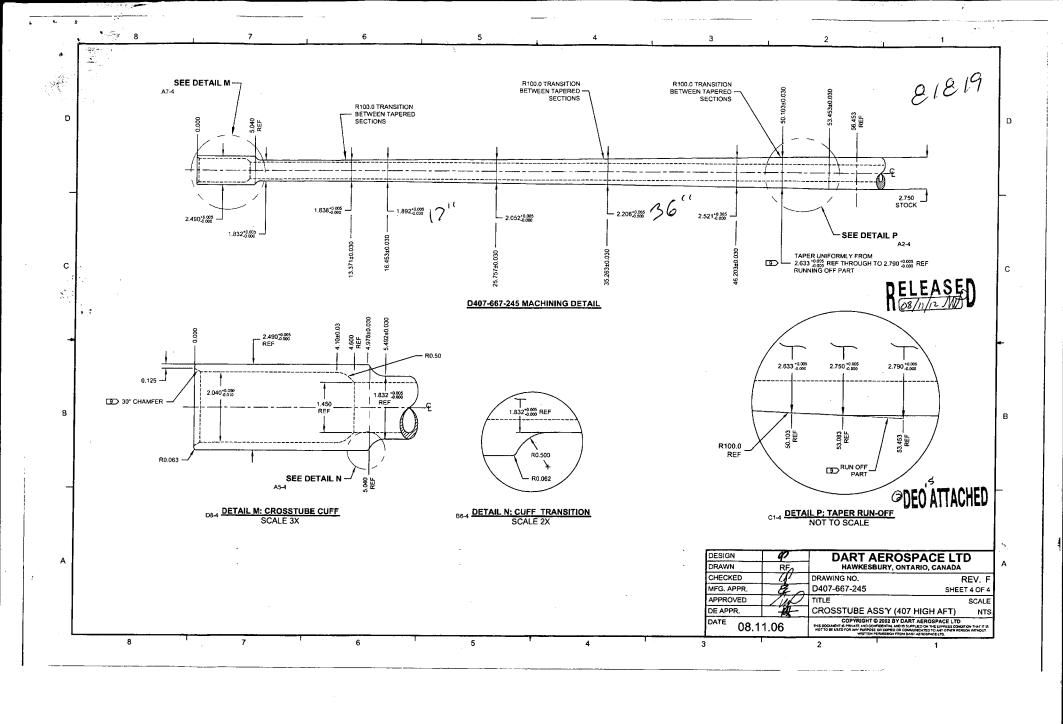
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		WORK ORDE	R NON-CONFORMA	NCE (NCR)		
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	R	:PAR #: Resolution:	STEP PROCEDURE CHAN PAR #: Fault Category Resolution: Disposition WORK ORDE STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORMAN STEP Description of NC Section A Corrective Action Section Initial Action Description	PAR #: Fault Category: NCR: Yes Resolution: Disposition: QA: N/C Clo WORK ORDER NON-CONFORMANCE (NCR WORK ORDER NON-CONFORMANCE (NCR STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty :PAR #:Fault Category:NCR: Yes No DQA: Resolution:Disposition:QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty Chief Eng/Prod Mgr :PAR #:Fault Category:NCR: Yes No DQA:Date:



Dart Aerospace	Ltd
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W/O:			WO	RK ORDER CHANG	ES		-		,
DATE	STEP	PRO	OCEDURE CHAN	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cated	lory:	 _ NCR: Yes	No DQ	⊥ A:	Date:	
		esolution:							
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NO	R)	4,111,		
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation		Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		on C	Chief Eng	QC Inspector
						!			
									1 1 1 1

DRAWING NO D407-667-2		TUBE ASSY (4	REV. F 07 HIGH AFT)	DART AEROSPACE I ENGINEERING ORD		SHEET NO. SCALE
DRAWN	4	CHECKED	q)	MFG. APPR.	APPROVED APPROVED	DE APPR.
DATE	11.04.08	DATE	11.04.12	DATE 11.04.12	DATE 11.04.12	DATE 11-04-12

PURPOSE:

REMOVED ABRASION STRIP IN FAVOR OF A THIN LAYER OF PROSEAL 890.

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

IS:

Item	Qty -245	Part Number	Description
3	0	D2856-400-773	ABRASION STRIP

WAS:

3	2	D2856-400-773	ABRASION STRIP

NOTES 2 AND 15, SHEET 1 ARE AMENDED AS FOLLOWS:

IS:

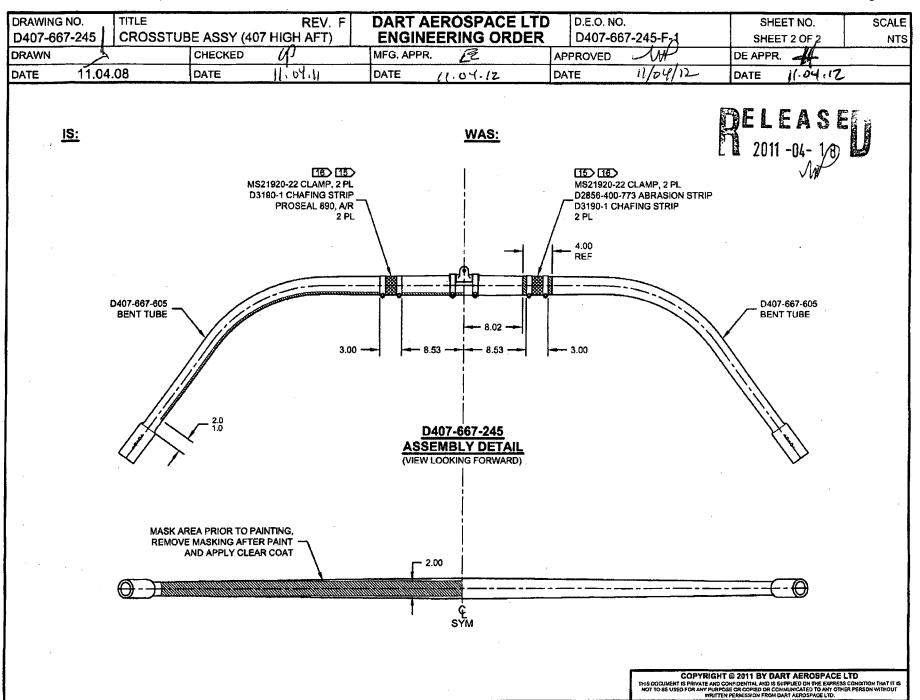
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
 MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND PAINT OUTSIDE PER DART QSI 005 4.2
 REMOVE MASKING AND APPLY CLEAR COAT
- 15) APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D3190-1 CHAFING SHIELDS AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL PROSEALED D3190-1 CHAFING SHIELDS ONTO CROSSTUBE BY APPLYING A THIN COAT OF PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.

WAS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
 PAINT OUTSIDE PER DART QSI 005 4.2
- 15) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 REF GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.



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		M	ORK ORDER CHANGI	ES				*
STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DO)A:	Date: _	1
Re	solution:	Disposit	ion:	QA: N/C	Closed: _		Date: _	
		WORK OR	DER NON-CONFORMA	NCE (NC	R)			
STEP	Description of NC Section A	Initial Chief Eng	Sign	& Sec		Approval Chief Eng	Approval QC Inspector	
	STEP	:PAR #:PAR #:	STEP PROCEDURE CH :PAR #:Fault Car Resolution:Disposit WORK ORI STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE :PAR #:Fault Category: Resolution:Disposition: WORK ORDER NON-CONFORMA STEP Description of NC Section A Action Description	WORK ORDER CHANGES STEP PROCEDURE CHANGE By :PAR #:Fault Category:NCR: Yes Resolution:Disposition:QA: N/C G WORK ORDER NON-CONFORMANCE (NC STEP Description of NC Section A	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date :PAR #:Fault Category:NCR: Yes No DC Resolution:Disposition:QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date Qty :PAR #:Fault Category:NCR: Yes No DQA: Resolution:Disposition:QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr :PAR #:Fault Category:NCR: Yes No DQA:Date:Resolution:Disposition:QA: N/C Closed:Date:



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W/O:			WORK ORDER	CHANGES				,
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Category:	NCR: Ye	es No DQ	A:	Date:	
	Resolution	1:	Disposition:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORDER NON-CON	FORMANCE (N	CR)			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Verification	Annual	A					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			

DRAWING NO.	TITLE		REV. F	DART AE	ROSPACE LTD	D.E.O. NO.	SHEET NO.	SCALE
D407-667-24	5 CROSSTUE	BE ASS'Y (4	07 HIGH AFT)	ENGINE	ERING ORDER	D407-667-245-F-2	SHEET 1 OF	NTS
DRAWN	P	CHECKED	ASS	MFG. APPR.	G	APPROVED W	DE APPR.	······································
DATE 1	1.09.07	DATE	11.09.19	DATE	11-09-19	DATE 11.09.19	DATE 11.09.19	

PURPOSE:

REPLACE MAGNOBOND WITH 3M DP460 SCOTCH-WELD EPOXY ADHESIVE

CHANGE:

IS:

Item	Qty -245	Part Number	Description
12	A/R	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD

WAS:

12	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

NOTE 12 & 17, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER QSI 015. LET CURE FOR 24 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURED FOR 24 HOURS.

WAS:

- 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.



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W/O: WDRK ORDER CHANGES							*			
DATE	STEP	PROCEDURE CHANGE By		PROCEDURE CHANGE By		PROCEDURE CHANGE By Date		Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		18	-							
					\$					
	:						·			

Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:	- 2 ,
	Resolution:	•.	Disposition:	QA: N/C Closed:	Date:	

		Description	of NC	Corrective Action Section B			Verification	Approval	Approval	
DATE	STEP	Section		Initial Chief Eng	•	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
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